Work Order ID 73448

Thursday, September 01, 2011 7:30:56 AM

Item ID: D2939-1 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Saddle LH In, 206

Start Date: 8/31/2011 **Start Qty:** 6.00 **Cust Item ID:**

Required Date: 9/16/2011 **Req'd Qty:** 6.00 **Customer:**

Reference:

Approvals: **Process Plan:** CL **Date:** 11/09/01 **Tooling:** **Date:** **Run Start** **Stop**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2939	Rev C								
100	HAAS CNC VERTICAL MACHINING #1	0.00							
HAAS 1	**Memo**	0.00				6	ø		
HAAS CNC vertical machine #1	Program part number and batch number.☐1-Inspect part number and batch number are programmed correctly.☐2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet ☐3-Machine Step No 2 of Folio and visually inspect as per								
110	CONVENTIONAL MILLING MACHINE	0.00							
Mill Conv	**Memo**	0.00				6	ø		
Conventional Milling Machine	Machine Keyway and inspect per attached dimension sheet								
120	QC1- Inspect dimensions to dimension sheet	0.00							
QC	**Memo**	0.00				6	ø		
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 73448

Thursday, September 01, 2011 7:30:56 AM

Item ID: D2939-1 **Accept** **Setup Start**

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Item Name: Saddle LH In, 206 **Stop**

Start Date: 8/31/2011 **Start Qty:** 6.00 **Cust Item ID:**

Required Date: 9/16/2011 **Req'd Qty:** 6.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00	JL	11-09-19		6	~~[illegible]~~	-	
QC	**Memo**	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00				6x	~~[illegible]~~	m-f 11/09/19	
HandFinish	**Memo**	0.00							
Hand Finishing									
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				6x	~~[illegible]~~	m-f 11/09/21	
Powdercoat	**Memo** 1:45	0.00							
Powder Coating	START TIME: _____ ☐FINISH TIME: _____ ☐OVEN TEMPERATURE: _____								

M118439 320°F 2:15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 73448

Thursday, September 01, 2011 7:30:56 AM

Item ID: D2939-1 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Saddle LH In, 206

Start Date: 8/31/2011 **Start Qty:** 6.00 **Cust Item ID:**

Required Date: 9/16/2011 **Req'd Qty:** 6.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00				4	0		11/09/21
QC Quality Control	Memo	0.00							
170	Identify as per dwg & Stock Location: ~~ST~~ 4289	0.00							
Packaging Packaging	Memo	0.00							6x 11-09-21
180	QC21- Final Inspection - Work Order Release	0.00							11/9/22
QC Quality Control	Memo	0.00							

MF 11-09-22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Thursday, September 01, 2011 7:30:53 AM

Work Order ID: 73448

Parent Item: D2939-1

Parent Item Name: Saddle LH In, 206

Start Date: 8/31/2011 **Required Date:** 9/16/2011

Start Qty: 6.00 **Required Qty:** 6.00

Comments: IPP: B□00.06.26□New DWG rev (mpp 2069)□EC
IPP Rev:C As per Rev C 07-03-19 JLM □□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001 Saddle Billet		Manufactured	No			100	Each	49.0000	1	6			

Location	Loc Qty	Loc Code			
MAT040	49				
64777	20				
66965	1				
69677	2				
70976	10				
72225	16		6 O	D.A	11/09/16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

DART AEROSPACE LTD	Work Order:	73448
Description: 206 Saddle, Inboard, Left side	Part Number:	D2939-1
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	**Min**	**Max**	**Go/No Go Gauge**	**1**	**2**	**3**	**4**	**By**	**Date**
A	0.100	0.140		.114	.119	.115	.114		
B	0.100	0.140		.113	.109	.110	.110		
C	0.100	0.140		.132	.120	.121	.122		
D	0.210	0.230		.223	.222	.222	.222		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.571	.571	.571	.571		
I	1.572	1.582		1.578	1.577	1.577	1.577		
J	2.495	2.505		2.506	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.315	.315	.315	.315		
M	0.235	0.240		.237	.237	.237	.238		
N	0.100	0.140		.116	.115	.115	.116		
O	0.540	0.560		.547	.550	.549	.548		
P	0.490	0.510		.502	.500	.500	.501		
Q	3.715	3.725		3.719	3.720	3.720	3.726		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		.252	.252	.251	.250		
T	0.100	0.180		.138	.138	.139	.139		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.368	1.367	1.367	1.367		
W	0.316	0.321		.316	.317	.317	.317		
X	1.250	1.270		1.262	1.263	1.262	1.264		
Y	1.565	1.585	DT8695 A/B	1.575	1.577	1.575	1.578		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	[illegible]	Audited by	JL
Date:	11/09/16	Date:	11-09-19

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order:	73448
Description: 206 Saddle, Inboard, Left side	**Part Number:**	**D2939-1**
Inspection Dwg: D2939 Rev. C		**Page 1 of 1**

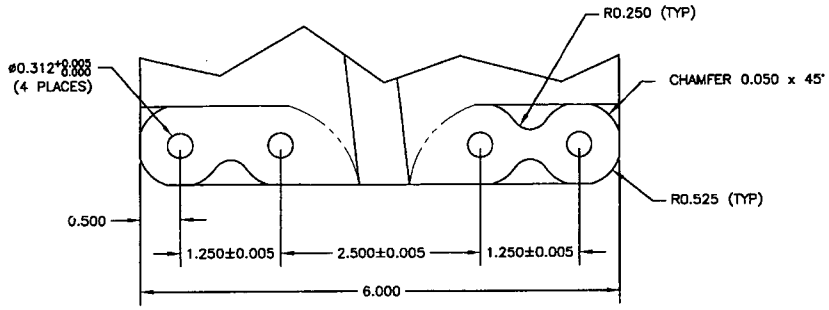
Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	**Min**	**Max**	**Go/No Go Gauge**	#5	#6	3	4	**By**	**Date**
A	0.100	0.140		.116	.115				
B	0.100	0.140		.112	.111				
C	0.100	0.140		.122	.122				
D	0.210	0.230		.222	.221				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.511	.511				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.258	.258				
L	0.312	0.317		.315	.315				
M	0.235	0.240		.238	.238				
N	0.100	0.140		.115	.115				
O	0.540	0.560		.547	.547				
P	0.490	0.510		.501	.502				
Q	3.715	3.725		3.720	3.720				
R	2.720	2.760		2.740	2.740				
S	0.240	0.270		.257	.257				
T	0.100	0.180		.139	.139				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		.317	.317				
X	1.250	1.270		1.262	1.262				
Y	1.565	1.585	DT8695 A/B	1.576	1.576				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

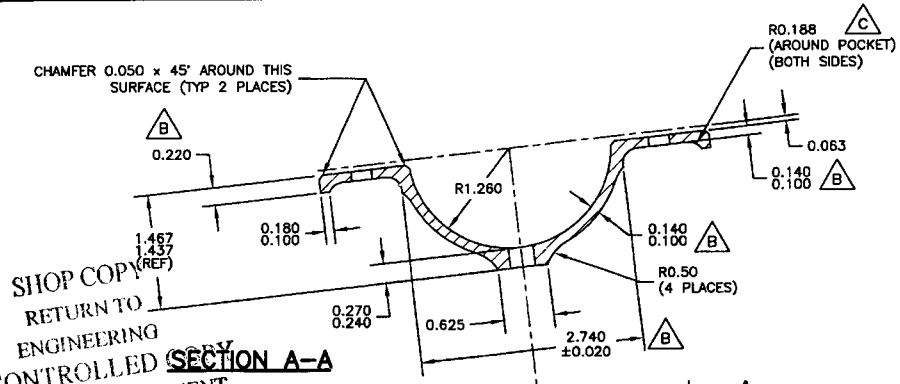
Measured by:	[illegible]
Date:	11/09/16

Audited by	SL
Date:	11-09-19

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

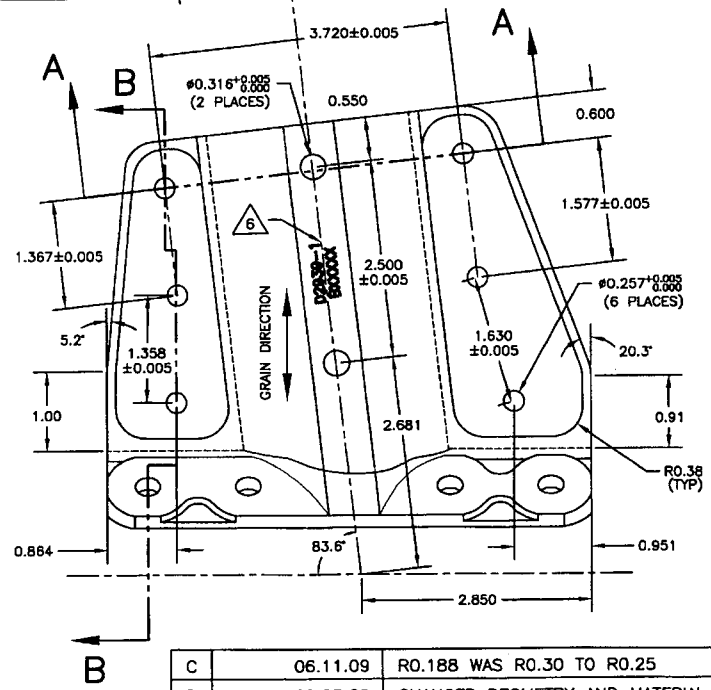


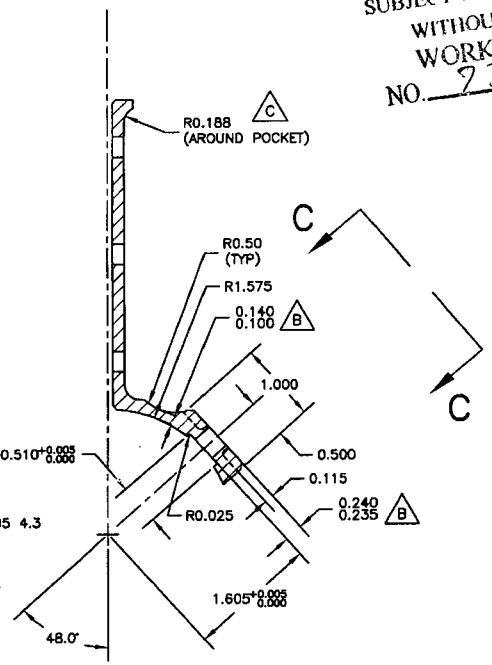
VIEW C–C



SECTION A–A

D2939–1 LH SADDLE (SHOWN)
D2939–2 RH SADDLE (OPPOSITE)





SECTION B–B

NOTES:
1) MATERIAL: ALUMINUM 7075–T7351 (QQ–A–250/12)
(MAKE FROM D6101–001 SADDLE BILLET, 7075)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
3) BREAK ALL SHARP EDGES 0.010 TO 0.020
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE INCHES
6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE

DESIGN	DRAWN BY CB	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED PH	APPROVED	DRAWING NO. D2939	REV. C SHEET 1 OF 1
DATE 06.11.09		TITLE SADDLE INSIDE	SCALE 2:3

07.02.12